

# Work Order ID 76459

November-15-11 8:04:24 AM

**\*76459\***

Page 1

Item ID: D407-802-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crew Door Opener Installation, RH

Start Date: 15/11/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/11/15

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D407-802-1	A	<u>1 SP</u>

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-012 CHG001

105

Pick Kit

0.00

**\*105\***

Packaging

Memo

0.00

Packaging

2x

SP  
12-9-27

110

QC4- 100% Inspect kits for completeness

0.00

**\*110\***

QC

Memo

0.00

Quality Control

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*76459\***

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Item ID: D407-802-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Crew Door Opener Installation, RH

Stop **\*NS2\***

Start Date: 15/11/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-012								
	Location: <u>2/B</u>								
	PPP rev: <u>2/B</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

2x 12/10/11 SP

12/10/13 JF

MF 12-10-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 76459

\*76459\*

Parent Item: D407-802-012

\*D407-802-012\*

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.12.02 per revA DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3552-15		Manufactured	No			105	Each	11.0000		2			
----------	--	--------------	----	--	--	-----	------	---------	--	---	--	--	--

\*D3552-15\*

Door Prop

\*\*

B88100 SP.

Location

Loc Qty

Loc Code

ST272

11

65119

11

D3622-5

Manufactured No

105 Each 12.0000

\*D3622-5\*

Ball Stud

\*\*

B804062 SP.  
B82314 SP.

Location

Loc Qty

Loc Code

ST070

12

65087

12

D4106-2

Manufactured No

105 Each 2.0000

\*D4106-2\*

Sill Douber, RH

\*\*

B77120.

Location

Loc Qty

Loc Code

ST127

2

64332

2

D4106-4

Manufactured No

105 Each 5.0000

\*D4106-4\*

Crew Door Douber, RH

\*\*

B79341 SP

12-9-28.

Location

Loc Qty

Loc Code

st128

5

64334

1

70064

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76459

\*76459\*

Parent Item: D407-802-012

\*D407-802-012\*

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

D4106-5 Manufactured No

105 Each

10.0000

\*D4106-5\*

Spacer Sill Doublor

\*\*

2

B80700 Sp. Sp.

## Location

## Loc Qty

## Loc Code

ST127

10

64335

2

64341

8

D4106-7

Manufactured No

105 Each

3.0000

\*D4106-7\*

Template

\*\*

2

B76460 1x Sp.  
B79172 1x

## Location

## Loc Qty

## Loc Code

ST127

3

64336

3

CR3523-4-02

Purchased No

105 Each

450.0000

\*CR3523-4-02\*

RIVET

\*\*

52

M120873 Sp. Sp.

## Location

## Loc Qty

## Loc Code

ST314

450

116391

100

116893

3

116915

1

117946

46

117978

200

118686

100

CR3523-4-4

Purchased No

105 Each

14.0000

\*CR3523-4-4\*

Rivet

\*\*

8

M119717 Sp. Sp.  
12-9-28

## Location

## Loc Qty

## Loc Code

ST314

14

115768

14

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76459

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

\*76459\*

\*D407-802-012\*

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

CR3523-4-5

Purchased

No

105

Each

74.0000

3

6

\*\*

\*CR3523-4-5\*  
Rivet

## Location

## Loc Qty

## Loc Code

ST314

74

117423

74

105

Each

104.0000

8

16

\*\*

CR3523-4-6

Purchased

No

\*CR3523-4-6\*  
Rivet

## Location

## Loc Qty

## Loc Code

ST314

104

115768

15

116606

89

105

Each

103.0000

7

14

\*\*

CR3523-4-07

Purchased

No

\*CR3523-4-07\*  
RIVET

## Location

## Loc Qty

## Loc Code

ST314

103

116606

100

17768

3

105

Each

5,242.000

8

8

\*\*

MS20426AD4-5

Purchased

No

\*MS20426AD4-5\*  
Rivet

## Location

## Loc Qty

## Loc Code

MEZZ

165

6733

165

ST317

5077

6874

5077

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76459

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

\*76459\*

\*D407-802-012\*

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

MS21073L5

Purchased

No

105

Each

73.0000

2

4

\*MS21073L5\*  
nut plate

\*\*

m122441 2x SP  
m120986 2x

Location

Loc Qty

Loc Code

ST302

73

117395

73

NAS1149C0532R

Purchased

No

105

Each

281.0000

6

12

\*NAS1149C0532R\*  
WASHER

\*\*

m122441 SP

Location

Loc Qty

Loc Code

ST297

281

116373

1

116513

53

118384

227

NAS1149C0563R

Purchased

No

105

Each

370.0000

6

12

\*NAS1149C0563R\*  
Washer

\*\*

SP 12-9-28

Location

Loc Qty

Loc Code

ST297

370

116391

182

117460

188

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 5.0 PARTS LIST

**REFERENCE ONLY**

## 5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
		D407-802-011	CREW DOOR OPENER KIT, LH
		D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4106-1	SILL DOUBLER, LH
	1	D4106-2	SILL DOUBLER, RH
1		D4106-3	CREW DOOR DOUBLER, LH
	1	D4106-4	CREW DOOR DOUBLER, RH
1	1	D4106-5	SPACER, SILL DOUBLER
1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER